

Date: Monday, 8/21/2006 2:16:27 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING LUG		
Job Number	: 28281		Part Number	: D22301		
Estimate Number	: 10255		Drawing Number	: D2230 REV F		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 8/21/2006 S.O. No. : N/A		Drawing Revision	: F		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 9/8/2006 Qty: 160 Um: Each		
Previous Run	: 28011					
Written By	:					
Checked & Approved By	:					
Comment	: Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion
Comment: Qty.: 0.0717 f(s)/Unit Total : 11.4744 f(s) Lug Extrusion D2423 Extrusion Batch: <u>B23379</u> En 06/09/12 x		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut D2423 extrusion to 0.82" Batch: <u>B23379</u> En 06/09/12 x		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 <u>Issue P.O 2013</u> <u>Code 06/09/13</u> <u>(160)</u> <u>Machinie per Jdg. D2230 RevF</u>
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per folio D2230-1 (Check for crack while loading into the machine.) 2-Tumble and deburr rough edges after tumbling		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <u>Receive & Inspect for Transit damage 10/4/16 (80)</u>
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK <u>20610-20 08 Counted</u>
Comment: SECOND CHECK		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

DQA: DDate: 06/01/20

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

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Drawing Name: MOUNTING LUG

Job Number: 28281

Part Number: D22301

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

GL

06/10/23 x 80

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FC 06 10 23 - 80

8.0 POWDER COATING

POWDER COATING



M101575

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

Y

06/10/23 x 80

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Aug 10/25 (PV)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST370*

Aug 10/25

80

11.0 DC

DOCUMENT CONTROL



(80)

Comment: DOCUMENT CONTROL

Inspection Level 21

Aug 10/26

Job Completion



Aug 10/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	28281
Description: Mounting Lug	Part Number:	D2230-1
Inspection Dwg: D2230 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	

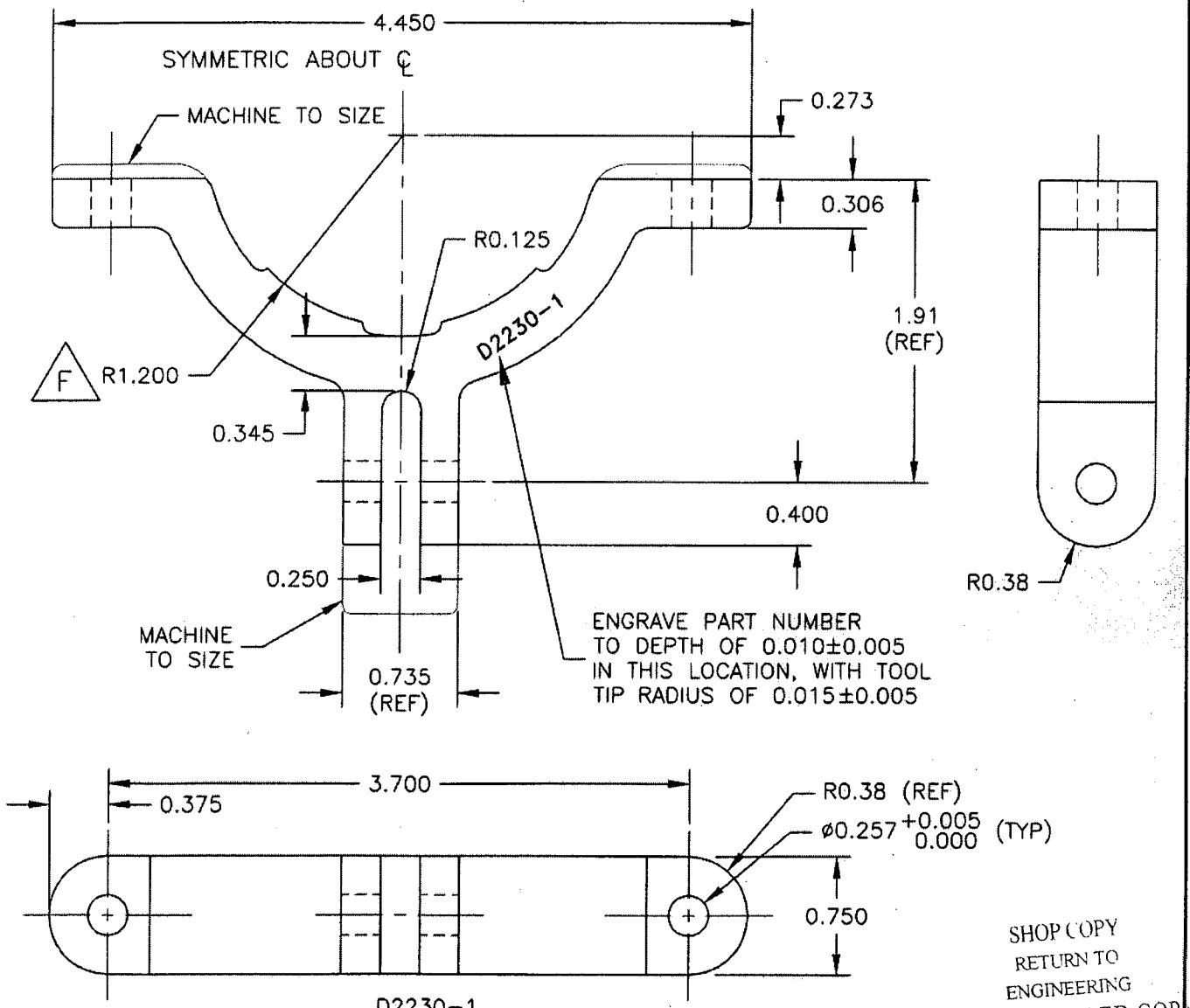
Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

DART



DESIGN	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	#	DRAWING NO. D2230
DATE			REV. F SHEET 1 OF 2
99.12.13			SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

RELEASED
99.12.21 DS

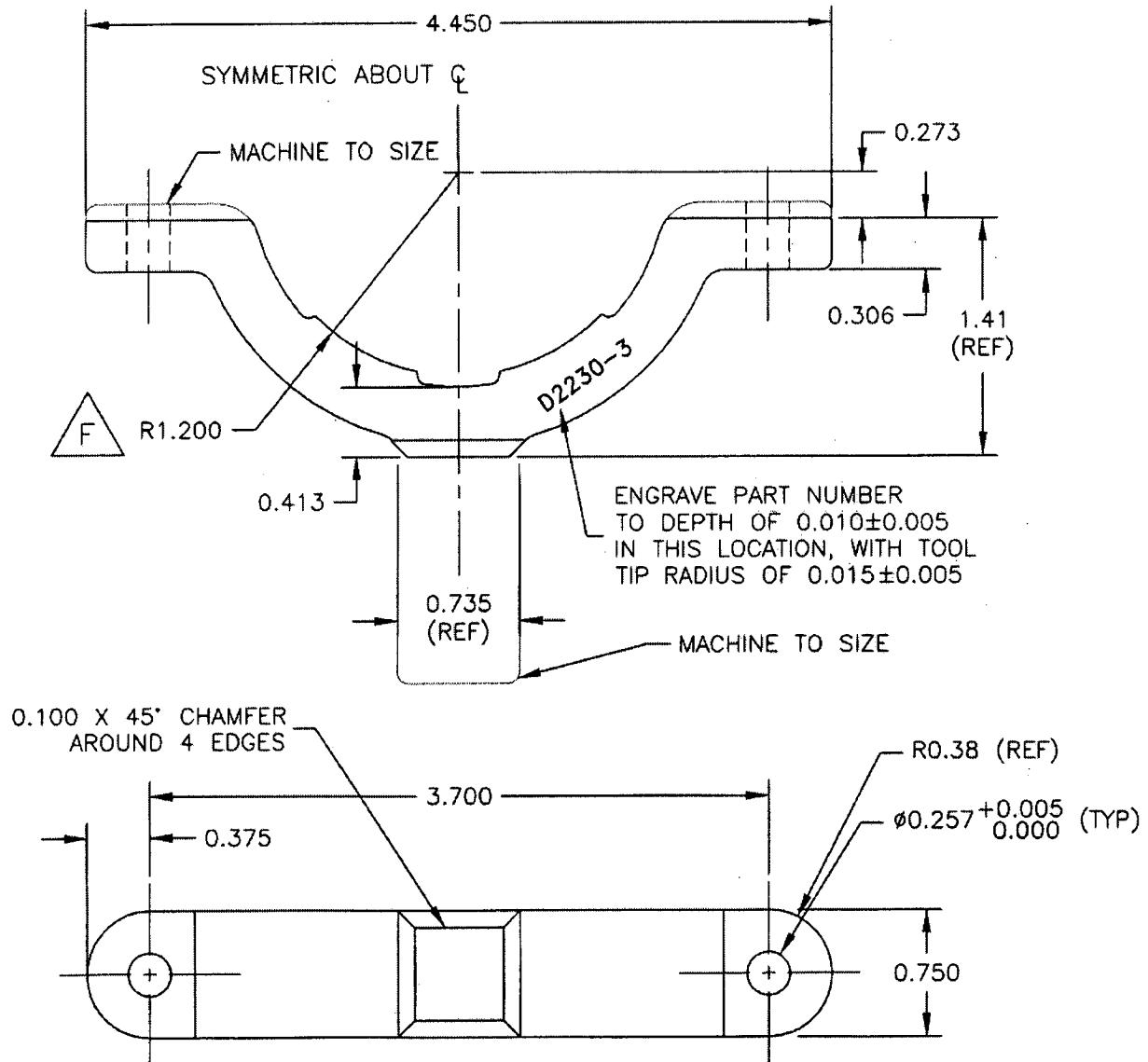


MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28281

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. F
DATE		D2230	SHEET 2 OF 2
99.12.13		TITLE	SCALE
		MOUNTING LUG	1:1

RELEASED
99.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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WORK ORDER
NO. 28281



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

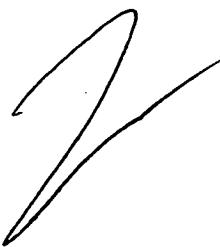
<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
79 80 2	D 2230-1	Mounting Lug	PO00002013 ✓

MATERIAL: supplied by DART D2423 B23779 ✓

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shig (Regular) Walz



Vankleek Hill, October 13, 2006

